

What is claimed is:

1. An insert molded member including a thin metal insert which is fixed at both ends in a resin injection chamber defined in molding dies,

5        wherein a resistance giving bent portion is provided in a resin supply passage connected to said resin injection chamber.

2. The insert molded member in accordance with claim 1, wherein said resistance giving bent portion is formed by a thinning portion of a main body  
10        of said insert molded member.

3. The insert molded member in accordance with claim 1, wherein said insert molded member is formed by a resin supplied from a sub port preventing said metal insert from being pulled out of said molding dies in  
15        addition to a resin supplied from said resistance giving bent portion.

4. An insert molded product comprising a resin body and a metal insert molded at least partly in said resin body,  
      wherein said resin body has a first portion, a second portion, and a  
20        third portion intervening between said first portion and said second portion,  
      said first portion of said resin body serves as a resin injection chamber in which said metal insert is supported when said insert molded product is manufactured by insert molding,  
      said second portion of said resin body serves as a resin supply passage  
25        for supplying resin to said resin injection chamber when said insert molded product is manufactured by insert molding, and  
      said third portion of said resin body serves as a resin decelerating portion for decelerating a flow velocity of said resin supplied into said resin injection chamber when said insert molded product is manufactured by insert  
30        molding.

5. The insert molded product in accordance with claim 4, wherein a rib structure including a plurality of recesses is employed to reduce a substantial thickness of said first portion of said resin body, and said recesses serve as a resin decelerating portion for decelerating a flow velocity of said resin supplied into said resin injection chamber when said insert molded product is manufactured by insert molding.

6. An insert molding apparatus for manufacturing an insert molded product having a metal insert molded at least partly in a resin body,  
10 wherein molding dies for forming said insert molded product comprises:  
a resin injection chamber in which the metal insert is supported;  
a resin supply passage for supplying resin to said resin injection chamber; and  
15 a resin decelerating portion intervening between said resin injection chamber and said resin supply passage for decelerating a flow velocity of said resin supplied into said resin injection chamber.

7. The insert molding apparatus in accordance with claim 6, wherein  
20 said metal insert has a bent portion being bent perpendicularly to a longitudinal direction of said metal insert and having a distal end being fixed in a fixing portion,  
said molding dies have a sub port supplying an auxiliary resin stream to a behind surface of said metal insert, and  
25 said sub port is located closer to said bent portion of said metal insert than an inlet port of said resin supply passage so that the resin stream entering from said sub port reaches said bent portion of said metal insert earlier than the resin supplied from the resin supply passage and pushes said bent portion of said metal insert against a thrust force acting when the resin  
30 entering from said resin supply passage collides with a front surface of said metal insert, thereby preventing said bent portion of said metal insert from

being pulled out of said fixing portion of said molding dies.